

Work Order ID 69290 *Split*

Friday, May 06, 2011 11:53:11 AM



Page 1

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00 *6*



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: *11-05-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev *D* Prog

Rev. *D* 2-Deburr if necessary

304.063

B11-5-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Salas

(+12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69290

Friday, May 06, 2011 11:53:11 AM

Page 2

Item ID: D3564-3

Accept

Revision ID:

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Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Debur if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

0.00

0.00

5/11/05/11

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D3429

0.00

0.00

8/1/05/11

(42)

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
11/232 Weld hardcoat as per Dwg D3437

0.00

0.00

EL 11-5-12

(40)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

5/11/13

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/11/13

(x6)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref.4 3 5.6) per QSI005 4.3

0.00

Memo

START TIME

FINISH TIME

OVEN TEMPERATURE:

0.00

12:00

12:30

3200

(6x) ✓ m-p 11/05/13

M115128

W/O:		WORK ORDER CHANGES					
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Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/5/13

200

Identify as per dwg & Stock Location: **FP19** 0.00

Packaging

Memo

0.00

Packaging

Gx 11/05/13

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/5/13

11-05-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:53:17 AM

Page 1

Work Order ID: 69290



Parent Item: D3564-3

Parent Item Name: Wearshoe

Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

98.5000

1.1

13,89474



1811-5-9

304/316 Sheet 063

Location

Loc Qty

Loc Code

MAT020

98.5

117275

98.5

117275

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69290
Description: Wearshoe		Part Number:	D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.223	✓		U/B02	
2.432	+/-0.010	2.438	✓		U	
2.50	+/-0.030	2.50	✓		U	
6.000	+/-0.010	6.006	✓		U	
12.104	+/-0.010	12.104	✓		T/B01	
18.000	+/-0.010	18.000	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	300X302	✓		U	
Ø0.188	+0.005/-0.001	.190	✓		U	
R0.375	+/-0.010	.375	✓		R.G.	
0.063	+/-0.010	.058	✓		U	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-5-9	Date: 11/5/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	

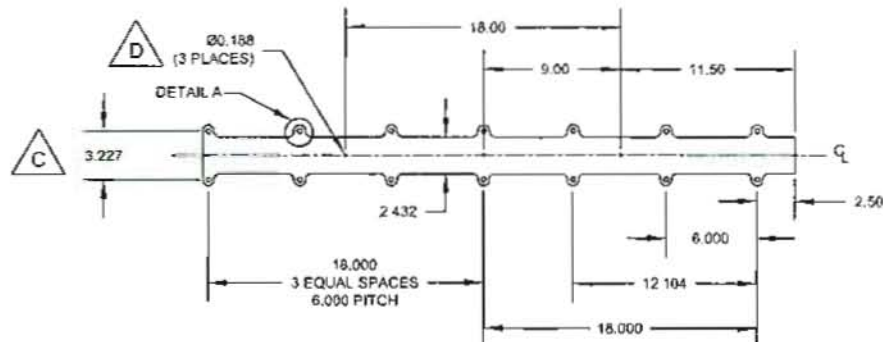
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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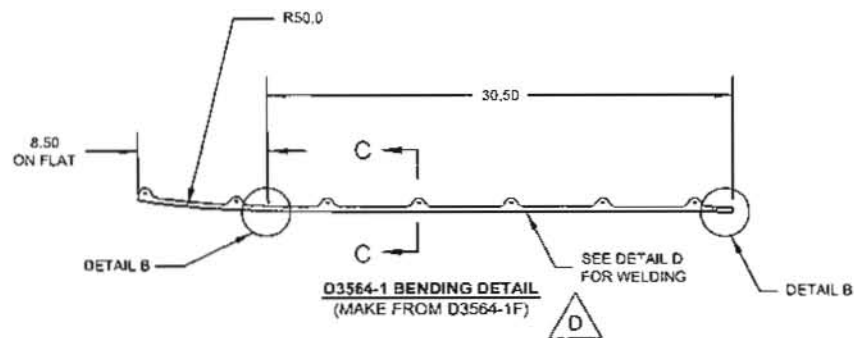
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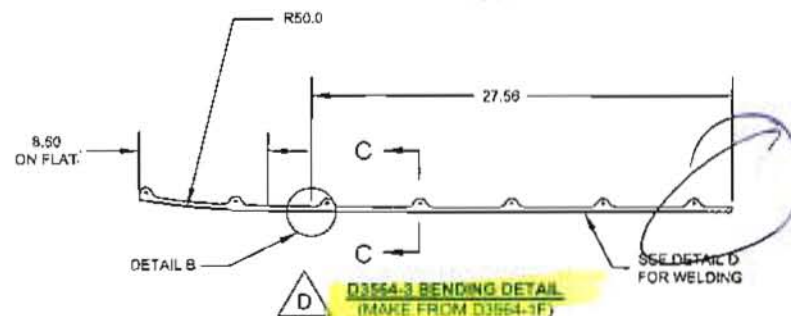
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN TO
DART AEROSPACE LTD
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER NO. C9290

11-056

RELEASED
07.09.04

	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A6: UPDATE NOTES: PG1 A8, PG3 B5,C6: ADD D3564-15; PG1 B8,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
D				
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG APPR	PH	D3564	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	WEARSHOE	1:8	
DATE	07.08.21			
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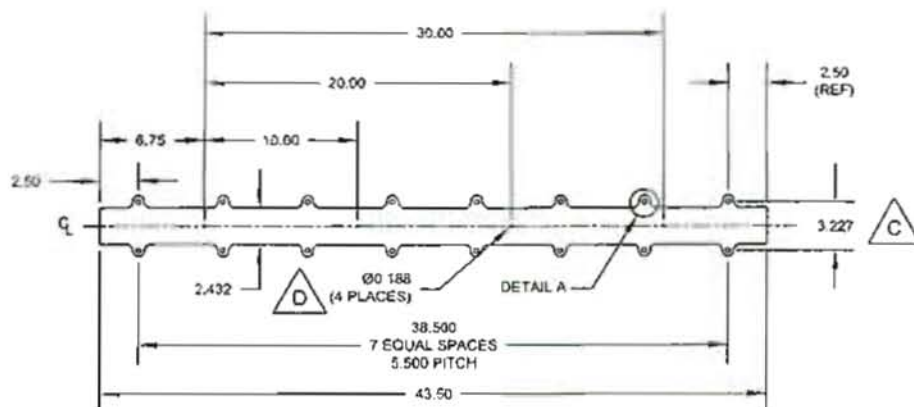
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

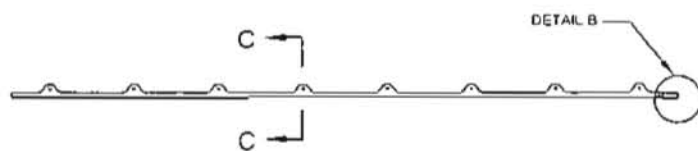
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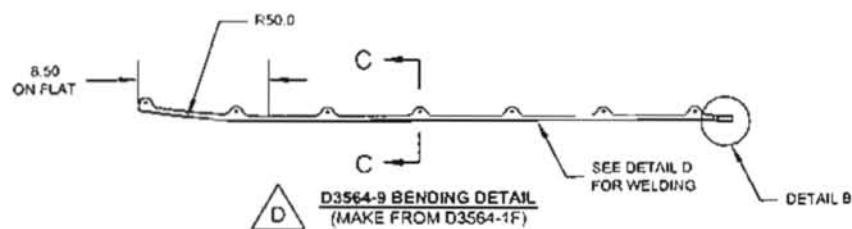
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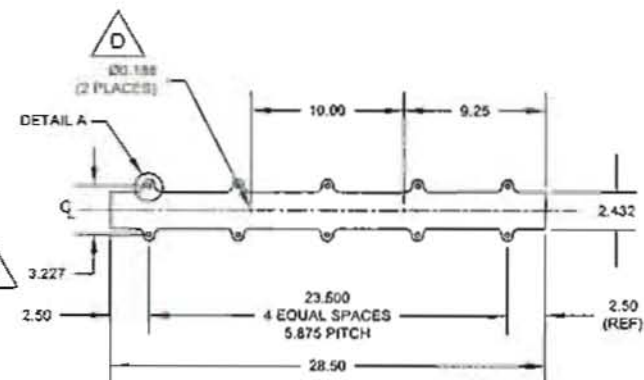
D3564-5F FLAT PATTERN



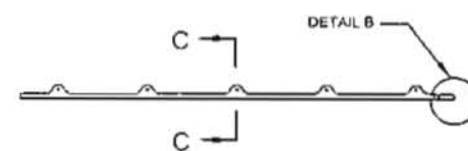
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



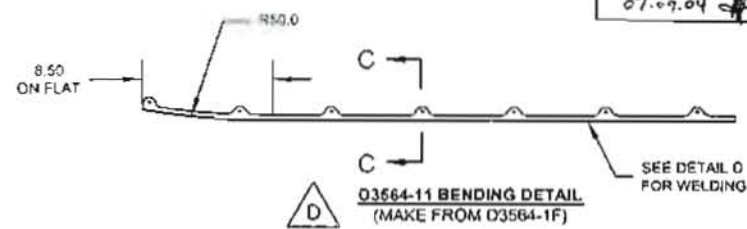
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD.	

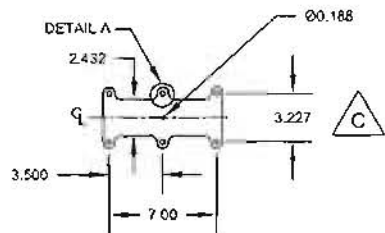
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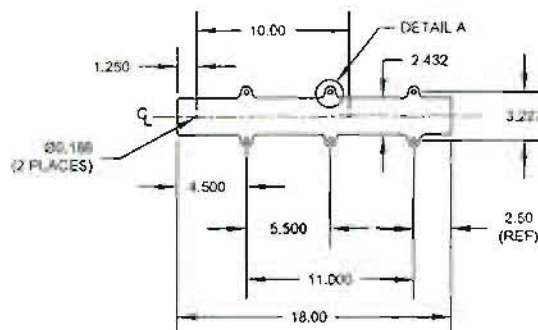
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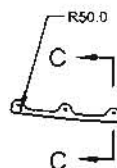
NOTE: Date & initial all entries



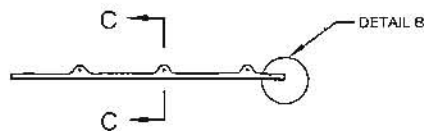
D3564-13F FLAT PATTERN



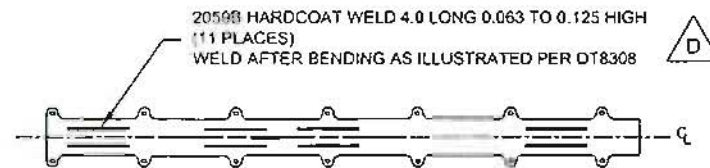
D3564-15F FLAT PATTERN



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



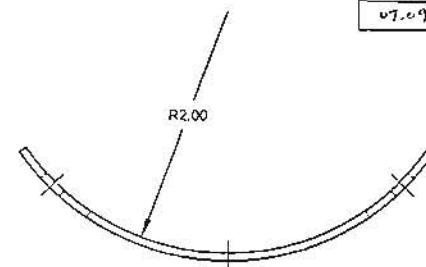
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



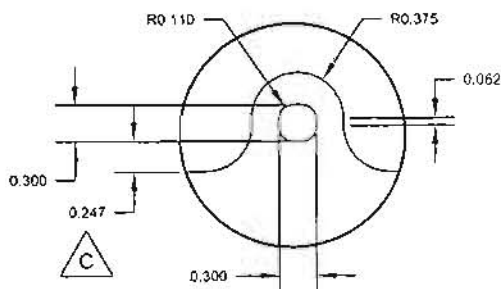
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

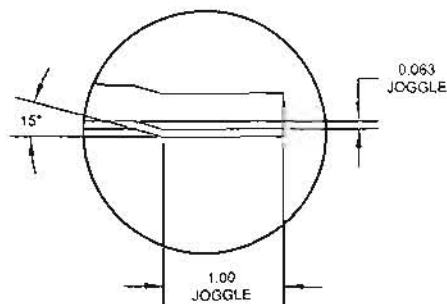
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEETS OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:1
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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